

Date: Tuesday, 8/28/2007 3:17:18 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 34291		
Estimate Number	: 10732		
P.O. Number	: N/A	Part Number	: D23241
This Issue	: 8/28/2007 S.O. No. : N/A	Drawing Number	: D2324 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 32278	Material	: N/A
Written By	:	Due Date	: 9/12/2007 Qty: 19 Um: Each
Checked & Approved By	:		
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	34291A	STOP	
Comment: Sub-Component STOP D2324-3 B 32353 SB			
2.0	34291B	STRAP	
Comment: Sub-Component STRAP D2324-5 B 30139 (4) (36) B 32872 SB			
3.0	AN312A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt M 103947 SD			
4.0	AN960JD10	Washer	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s) Washer M 105442 SD			
5.0	MS21042L3	Nut	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Nut M 104934 SD 07/09/24 (19)			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2324.			

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 34291

Part Number: D23241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*in 06/24 (18) (19) (20)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m105068 PR 07-09-25 (19)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*(B) 7/5/26 (19)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57211*

*(C) 7/5/26 (19)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(19) 07/09/26*

Job Completion



*u 07/09/26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

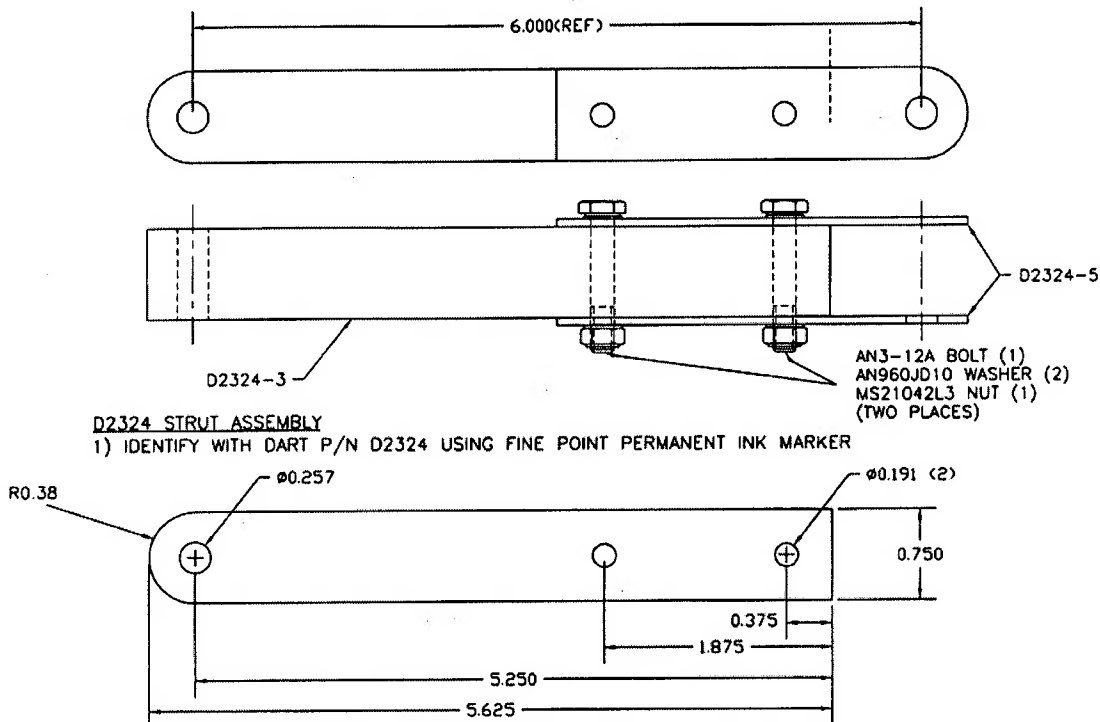

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

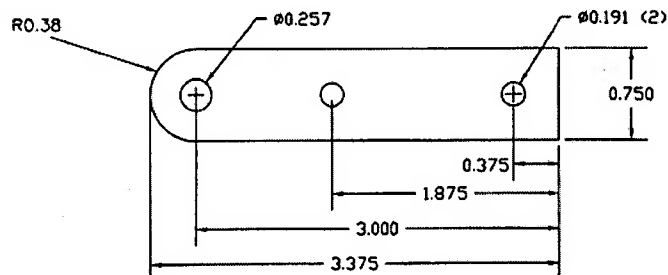
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 **D2324 STRUT ASSEMBLY**

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34291